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D3121-141
Job Sheet 183925



Part No: D3121-141

Job Qty: 10 ea

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/28/18

Job Tracking No:

Due Date: 10/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP Rev: Pick: A 04.02.18 New issue KJ/DS IPP Rev: B ECN 1060 07-11-12 DD verified by: EC
IPP Rev: C New Dimensions for Blank Size 08-07-23 JLM Verified By: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	10/12/18	10/12/18	0.00	0.00	Start Up Machining-1		18/10/17 V48
100	Bandsaw	10 pcs	10/12/18	10/12/18	0.00	1.13	Bandsaw1		
110	CNC Vertical Machining	10 pcs	10/12/18	10/12/18	0.47	19.61	HAAS1-3		
120	QC	10 pcs	10/12/18	10/12/18	0.00	0.00	QC2 Machining-1		
130	QC	10 pcs	10/12/18	10/12/18	0.00	0.00	QC8 Machining-1		18/10/12
140	Small Fab	10 pcs	10/12/18	10/12/18	0.00	0.28	Small Fab-2		DAS 38
150	QC	10 pcs	10/12/18	10/12/18	0.00	0.00	QC5		508401 4X
160	Packaging	10 pcs	10/12/18	10/12/18	0.00	0.00	Packaging3-1	5/018	OCT 17 2018
170	QC21-SA	10 Ea	10/12/18	10/12/18	0.00	0.00	QC21	9-89	OCT 17 2018

Part Op 100 - Cut blanks: (1.250" x 2.000") 6.600" long
Descriptions: 110 - 1-Machine D3121-111 as per Folio FA361 and Dwg D3121 Identify as D3121-111 3-Scribe batch number
140 - Assemble D3121-141 as per Dwg D3121.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-B1.250X2.000	17-4 SS Bar 1.250 x 2.00	5.5000 ft (.55 ea)	90-Start up Operation	5088987
D3121-21	Bolt	10 Ea (1 ea)	140-Small Fab	5097200
D3121-241	Bearing Assembly	10 Ea (1 ea)	140-Small Fab	5108401 4X
				5115958

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-B1.250X2.000	6	9	0
140-Small Fab	D3121-21	10	71	0
	D3121-241	10	11	0

Part Specifications

Specifications could not be found.

DART AEROSPACE LTD		Work Order: 183925
Description: Bracket		Part Number: D3121-111
Inspection Dwg: D3121	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	0.393	✓			
0.75	+/-0.030	0.751	✓			
0.375	+/-0.010	0.375	✓			
2.14	+/-0.030	2.143	✓			
1.96	+/-0.030	1.964	✓			
0.280	+/-0.010	0.283	✓			
3.330	+/-0.010	3.330	✓			
3.630	+/-0.010	3.633	✓			
R0.25	+/-0.030	0.250	✓			
R0.375	+/-0.010	0.375	✓			
Ø0.201	+/-0.010	0.201	✓			
0.100	+/-0.010	0.095	✓			
4.580	+/-0.010	4.583	✓			
6.18	+/-0.030	6.182	✓			
5.89	+/-0.030	5.888	✓			
0.080	+/-0.010	0.078	✓			
0.300	+/-0.010	0.301	✓			
30°	+/-0.1°	30°	✓			
R0.25	+/-0.030	0.250	✓			
0.130	+/-0.010	0.133	✓			
0.664	+/-0.010	0.664				
0.381	+/-0.010	0.377	✓			
0.201	+/-0.010	0.200	✓			
0.400	+/-0.010	0.396	✓			
0.580	+/-0.010	0.586	✓			
100°	+/-0.1°	100°	✓			
0.032	+0.000/-0.010	0.029	✓			

Measured by: DAS 57	Audited by:	Preliminary Approval:
Date: 9-89 18/10/06	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue P/O D3121-141	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	
D	08.01.16	Dimensions updated per Dwg Rev. E	KJ/EC/DD	
E	08.05.28	Tolerance revised for Ø0.201 dimension	KJ/DD	
F	13.10.22	Tolerance revised for Ø0.201 dimension	KJ	